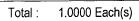
Date: Monday, 5/28/2007 11:58:06 AM User: Kim Johnston	Dunana Chast		
rý:	Process Sheet		
Previous Run : 32522 Written By Checked & Approved By Comment : Est Rev: A 05.10.13 N Est Rev: B 06-06-08	Part Number Drawing Number Project Number Project Number Drawing Revision Material Due Date S. 2 & . ew Issue KJ/JLM As per DSI9336 JLM As per Rev C JLM	: FLOAT SKIDTUBE : D412742011 : IIN D412-742 REV C : N/A : C : 1	1 Um: Eac
Additional Product			
Job Number:			
Seq. #: Machine Or Operation:	Description :		
1.0 DC	DOCUMENT CONTROL		07,06.05
Photocopy bluefile and create la		W RJ	94,06,00
Comment: Sub-Component FLOAT SKID D412-742-041 B 3-253	ASSEMBLY ASSEMBLY		
3.0 D412742015 Comment: Qty.: 1.0000 Each(s)/Unit	Electric Step Kit Total: 1.0000 Each(s)		
Electric Step Kit Batch: 4.0 D2571	5/2	-	
Comment: Qty.: 1.0000 Each(s)/Unit Pick: Qty Part Number Description 1 D2571 Saddle Fwd Ou		SP	, .

5.0

D2572

Saddle, Fwd, In

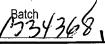
Comment: Qty.: 1.0000 Each(s)/Unit

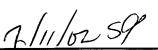


Pick:

Qty Part Number 1 D2572

Description Saddle Fwd Inside





W/O:		WORK ORDER CHA	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:				

QA: N/C Closed: ____ Date: ____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Ammarial	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng		

Monday, 5/28/2007 11:58:06 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: FLOAT SKIDTUBE Customer: CU-DAR001 Dart Helicopters Services Part Number: D412742011 Job Number: 32523 Job Number: Description: Seq. #: Machine Or Operation: Saddle, Aft, Out 6.0 D2573 Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Saddle Aft Outside 1 D2573 D2574 7.0 Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Saddle Aft Outside 1 D2574 D2876 8.0 Comment: Qty.: 2.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Saddle Spacer 2 D2876 D2877 Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: SP **Qty Part Number** Description D2877 Saddle Spacer 2 D34031 10.0 Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s) Pick: B33786, **Qty Part Number** Description 16 D3403-1 Bushing D2747 Set Screw 11.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) 7/11/or 50 Pick: **Qty Part Number** Description 4 D2747

W/O:		WORK ORDER CHA	CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
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Monday, 5/28/2007 11:58:06 AM Date: Kim'Johnston User: **Process Sheet** Drawing Name: FLOAT SKIDTUBE Customer: CU-DAR001 Dart Helicopters Services Part Number: D412742011 Job Number: 32523 Job Number: Description: Seq. #: Machine Or Operation: Set Screw 12.0 D35331 Comment: Qty.: 2.0000 Each(s) 2.0000 Each(s)/Unit Total: Set Screw BATCH: 13.0 AN4C6A Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s) Pick: Batch Qty Part Number Description Bolt 16 AN4C6A D34033 Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: **Qty Part Number** Description 8 D3403-3 Bushing D3405041 15.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Description **Qty Part Number GHW** Lug 1 D3405-041 D3405043 16.0 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Comment: Qty.: 59 Pick: Description Batch SY/ **Qty Part Number** 1 D3405-043 AN4C46A 17.0 4.0000 Each(s) Comment: Qty.: 4.0000 Each(s)/Unit Total: Pick: 7/11/02 SP **Qty Part Number** Description Bolt 4 AN4C46A

W/O:			WORK ORDER	CHANGES					
DATE	STEP	PR	OCEDURE CHANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	Approval	Approval QC Inspector		
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	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Corrective Action Section B Verification Section C Section C	STEP Description of NC Section A Section B Section B Verification Approval Chief Eng		

Monday, 5/28/2007 11:58:06 AM Date: Kim 'Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: FLOAT SKIDTUBE Part Number: D412742011 Job Number: 32523 Job Number: Description: Seq. #: Machine Or Operation: BOLT 18.0 AN4C52A Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: M103914 SP Batch **Qty Part Number** Description Bolt 8 AN4C52A AN6C12A Comment: Qtv.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: **Qty Part Number** Description Bolt 8 AN6C12A 20.0 AN960C416L Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s) Pick: Qty Part Number Description **←** 32 AN960C416L AN960C616L WASHER 21.0 Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Qty Part Number Description Washer -8 AN960C616L 22.0 MS210434 Nut Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s) Pick: 7/11/02

7	WORK ORDER	RCHANGES				
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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: No:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	
			N/C Close	d:	Date:	

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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Monday, 5/28/2007 11:58:06 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: FLOAT SKIDTUBE Customer: CU-DAR001 Dart Helicopters Services Part Number: D412742011 Job Number: 32523 Job Number: Description: Seq. #: Machine Or Operation: Inventory NAS1515H4L 32.0000 Each(s) 32.0000 Each(s)/Unit Total: Comment: Qty.: 54 Pick: Qty Part Number Description Washer 32 NAS1515H4L 24.0 Inventory 8.0000 Each(s) Comment: Qty.: Total: 8.0000 Each(s)/Unit Pick: 50 Description Qtv Part Number Washer 8 NAS1515H6L 25.0 NAS1515H7 Inventory Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s) Pick: Description Batch Qty Part Number 4100 T Washer Tow Ring D3407041 26.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: $\leq \mathcal{O}$ **Qty Part Number** Description **TOW RING** D3407-041 27.0 D34173 Washer Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: 7/11/02 SA Description ら 35 5/9、 **Qty Part Number** WASHER D3417-3

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W/O:		WORK ORDER CHANGES					
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			QA:	N/C Closed	l:	Date:	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Ammenial	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
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Monday, 5/28/2007 11:58:06 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: FLOAT SKIDTUBE Customer: CU-DAR001 Dart Helicopters Services Part Number: D412742011 Job Number: 32523 Job Number: Description: Seq. #: Machine Or Operation: washer 28.0 D34561 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Qty Part Number Description WASHER D3456-1 29.0 AN4C7A Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt INSPECT 100% KITS FOR COMPLETENESS 30.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 31.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-742-9 Location: QC21 32.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

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W/O:		WORK ORDER CHAI	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
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Part No	·	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
			QA: N	V/C Close	d:	Date:	

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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				

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Date:

Monday, 5/28/2007 11:58:34 AM

User

Kim Johnston

Process Sheet

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 32523A **Estimate Number**

: 12876

P.O. Number

First Issue

Previous Run

This Issue

: 5/28/2007 Prsht Rev.

: NC

: 11

: 32522A

Type

S.O. No. :

: LANDING GEAR

Written By Checked & Approved By

Comment

: Est Rev A 05 Est Rev B 06.02.13

ECN 773 dwg @ rev.D

Est Rev:C 07-05-28 As per Rev F KJ/JLM EC JLM

Material

Due Date

6/30/2007

: D412742041

D3391 REV F

: N/A

: F

: FLOAT SKID ASSEMBLY

Qty:

1 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

If D412-742-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-041 CHG003

Total:

D3391013 2.0

Mid Tube Assembly

1.0000 Each(s)

Comment: Qty.: pick:

Part Number Description

1.0000 Each(s)/Unit

D3391-013 Mid Tube Assembly

3.0 D3391015

Comment: Qty.:

Aft Tube Assembly

1

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

pick:

Qty Part Number Description

D3391-015 Aft Tube Assembly

4.0

D35641

WEARSHOE



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

1.0000 Each(s)

WEARSHOK Batch:

Dart Aerosp	ace Ltd
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Dart Ae	rospace Ltd									
W/O:			WORK ORDER	CHANGES						
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _			
				QA	: N/C Close	d:	Date: _			
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NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Annessal	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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				•				

Date: Monday, 5/28/2007 11:58:34 AM Kim Johnston User: **Process Sheet** Drawing Name: FLOAT SKID ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D412742041 Job Number: 32523A Job Number: Description: Seq. #: Machine Or Operation: **WEARSHOE** 5.0 D35643 Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total: **WEARSHOE** Batch: WEARSHOE 6.0 D35645 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) WEARSHOF! Batch: **GASKET** 7.0 D35661 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: **GASKET** Batch: 8.0 D35665 **GASKET** 1.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit__ Total: **GASKET** Batch: BOLT 9.0 AN3C4A Comment: Qty.: 24.0000 Each(s) 24.0000 Each(s)/Unit Total: **BOLT** Batch: BOLT 10.0 AN3C6A 12.0000 Each(s) Comment: Qty.: 12.0000 Each(s)/Unit Total: **BOLT** Batch: BOLT 11.0 AN3C7A Comment: Qty.: 8.0000 Each(s)/Unit 8.0000 Each(s) Total: **BOLT**

Dart Aerospace L	Dart	Aer	osp	ace	Ltd
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W/O:		WORK ORDER CH	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	:									
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _				
			QA: I	N/C Close	d:	Date: _				

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Varification	A	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

Date:		2007 11:58:34 AM		
User:	Kim Johnston		Process Sheet	
Cust	omer: CU-DAR	001 Dart Helicopters Services	Drawing Name: FLOAT SKID ASSEMBLY	
v				
Job Nui	mber: 32523A		Part Number: D412742041	[
Job Numbe	er:			- 1
Seq. #:	Machina	Or Operation:	Description :	
12.0			washer	
12.0	/((30001			
С	Comment: Qty.:	44.0000 Each(s)/Unit Total:	1: 44.0000 Each(s)	
	washe		M105 143 (xx) m106043(36) FL	
	Batch			\dashv
13.0	MS27039	J412 Bibinita (na 1881) ibn (na 1	SCREW IIIIIIIIIII	
C	Comment: Qty.:	4.0000 Each(s)/Unit Total :	: 4.0000 Each(s)	\neg
	SCRE			j
	Batch		FX	
14.0	NAS1515	H4L /	Inventory	
				ı
	omment: O:	4 0000 Feeb (a) // leit	4 0000 Fach(s)	\dashv
	comment: Qty.: Invent	4.0000 Each(s)/Unit Total:	: 4.0000 Each(s)	, [
	Batch:	11199111	f Z	
15.0			WASHER	
			·	\dashv
C	Comment: Qty.;	4.0000 Each(s)/Unit Total:	: 4.0000 Each(s)	
	WASH Batch:	1 (6) / 1 (6	f.	
16.0	HAND FIN		HAND FINISHING RESOURCE #1	\dashv
С	comment: HAND	FINISHING RESOURCE #1		
	4.0		2/025 with LDS 3 on per Dwg D2304	
	1-Spra	19 Inside tube of D3391-0217-0237	3/-025 with LPS-3 as per Dwg D3391	
	AVI.		13 (p.0)	
	2-Insta	all tubes together and seal them a	all the way around using Sikaflex 241/291. Ensure tube ends line-up	
		addle holes for proper alignment.	t. using 7/16"—The Pins.	
	A/R	Sikaflex-241/-291 M/03	١١١/٦ / ٢٥٤٥	7
	Expiry	date: UV U	/ g j // / C	1
	3-Insta	ill wearplates as per Dwg D3391	Ensure that plastic washers are against wearplate, then topped	
		e SS washer. Coat bolts with LF	,	
		II bolts with sikaflex exept ones w	with inserts on inside of tube , hand tighten only bolts with no sikaflex.	
	A/ Ř	LPS Procyon M/04		-
	A/R	Sikaflex-241/-291	<u>15 > 85 </u>	
	Expiry	date: DO-O)	/.	
	/ Dom	ove "T" pins once sikaflex is dry.	l'	- 1
	4-13611	ove i pine once sinalier is dif.	,	- 1

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W/O:		WORK ORDER CHA	ANGES				
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Part No	:	PAR #: Fault Category:	NCR: Y	es No	DQA:	Date: _	
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	ŀ	Description of NC		Corrective Action Section E		Verification	Ammanal	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
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Date: Mon	day, 5/28/2007 11:58:34 AM	
	Johnston	Process Sheet
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: FLOAT SKID ASSEMBLY
4	205024	Part Number: D412742041
Job Number: Job Number:	32523A	Part Number. D412/42041
JUD HUITIDGI.		
Seq. #:	Machine Or Operation:	Description :
	5-Coat all exposed hardware with LPS F	Procyon. Remove any excess off with MEK degreaser.) Full 67/11/07
17.0	QC5	INSPECT WORK TO CURRENT STEP
	nt: INSPECT WORK TO CURRENT STEP	
18.0	PACKAGING 1	PACKAGING RESOURCE #1
Comme	nt: PACKAGING RESOURCE #1	
	Identify and pack for shipping as per PP	
	Location: 3	32523 607/1/07 (1)
19.0	QC21	FINAL INSPECTION/W/O RELEASE
Comme	nt: FINAL INSPECTIONW/O RELEASE	
Job Completion		W Stell-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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			QA:	N/C Clos	sed:	Date: _	
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section B		Verification	Ammanal	Ammunual		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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